












Date: Tuesday, 1/10/2006 3:18:26 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT STEP MOUNTING LUG
Job Number	: 25430		
Estimate Number	: 11750		
P.O. Number	: N/A	Part Number	: D34593
This Issue	: 1/10/2006 S.O. No. : N/A	Drawing Number	: D3459 PRELIMINARY
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 1/17/2006
Checked & Approved By	: <u>SEE COMMENT BELOW</u>	Qty:	21 12 ²¹ 20 Um: Each
Comment	: Est Rev: A New Issue 06-01-06 JLM	multiples of 3	
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0187X04000	6061-T6 Bar .178" x 4.0"	
			
Comment: Qty.: 0.3644 f(s)/Unit Total: 7.2870 f(s) 4.00" X .188" BAR 6061-T6 (M6061T6B4.000X.188) Batch: <u>JL M19524</u>			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW <u>3.80</u> <u>ER</u> Cut Blanks to <u>4.165</u> Long <u>4.165</u> Long			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per folio FA620 & DWG D3459 2-Deburr			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
5.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/07

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.01.11	3	461 dimension too thick. fix prog. → done. <u>wrong work order</u>		Scrap & destroy No replace	SA 06.01.11	06.01.11		06.01.11

NOTE: Date & initial all entries

Date: Tuesday, 1/10/2006 3:18:27 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP MOUNTING LUG

Job Number: 25430

Part Number: D34593

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

Handwritten: 1-6-06-02-6 = 21

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Handwritten: 500 06/02/08 (21) 06/02/07

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

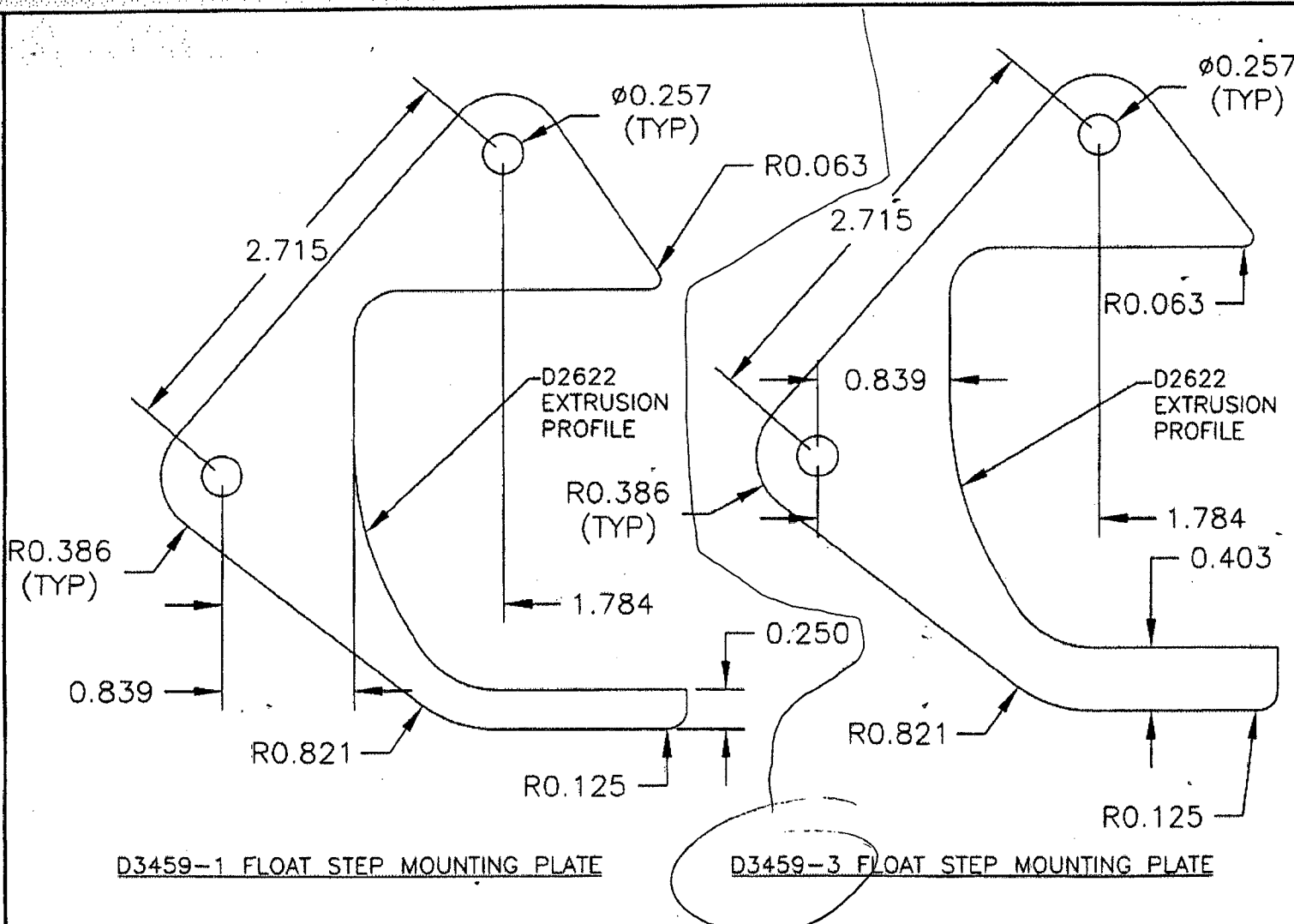
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. A
04	04	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
<i>[Signature]</i>	<i>[Signature]</i>	D3459	
DATE	TITLE	SCALE	
05.09.23	FLOAT STEP MOUNTING PLATE	1:1	
A	05.09.23	NEW ISSUE	



D3459-1/-3 FLOAT STEP MOUNTING PLATE

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK
(REF DART SPEC. M6061T6S.188)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.14

DART AEROSPACE LTD	Work Order:	25430
Description: Float step mauling plate	Part Number:	D 3459-3
Inspection Dwg: D 3459 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☒ Prototype

[illegible]

Measured by:	J.L	Audited by:	MS	Prototype Approval:	
Date:	06.01.31	Date:	06/01/31	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	